

Date: Wednesday, 25/03/2009 10:37:39 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 46688	
Estimate Number : 11683	
P.O. Number :	Part Number : D2888
This Issue : 25/03/2009 S.O. No. :	Drawing Number : D2888 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 45925	Material :
Written By : <i>[Signature]</i> 09-03-25	Due Date : 01/04/2009 Qty: 16 Um: Each
Checked & Approved By :	
Comment : Est. C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X03500	6061-T6 Bar 2.50 x 3.50
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NOT REMOVE FROM
COMPUTER



Comment: Qty.: 0.3938 f(s)/Unit Total : 6.3000 f(s)
 6061-T6 Bar 2.5" x 3.5"
 Material: 3.5" x 2.5" bar 6061-T6

Batch *M110936* *mk 09/03/25* (12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 4.20" long
 (Grain along 4.20")

mk 09/03/25 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2888
 Deburr and Tumble

mmf 09/03/30/JL 09/03/31 (11)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/03/30/JL 09/03/31 (11)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SP 09/04/01 (10)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

BL 09-04-3 (10)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 46688

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110 93A

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

BR

09-04-06

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/04/06

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 480

9/4/06

SP

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/07

Job Completion



U 09-04-07

DART AEROSPACE LTD		Work Order:	46688
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888		Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

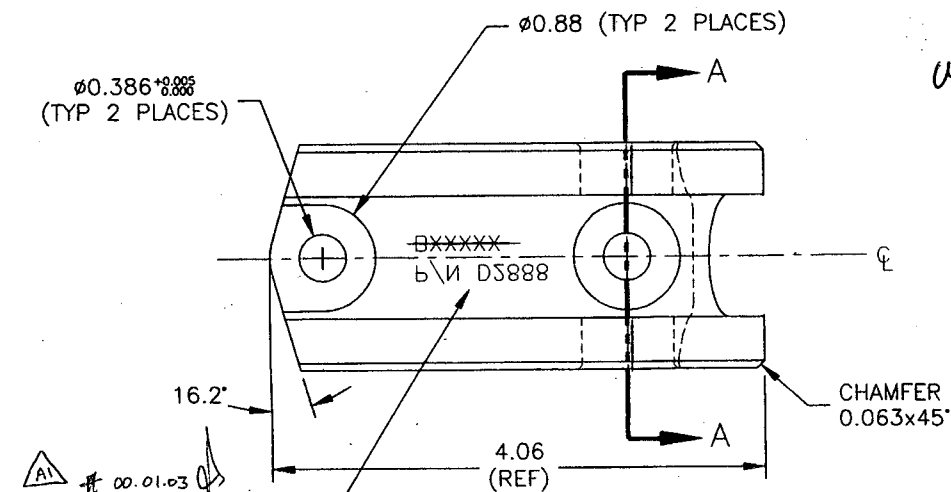
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0.386	✓			
Ø0.88	+/-0.030	0.88	✓			
0.063 x 45°	+/-0.010	0.063 x 45°	✓			
4.06	+/-0.030	4.06	✓			
Ø0.760	+0.005/-0.000	0.762	✓			
3.48	+/-0.030	3.48	✓			
2.500	+/-0.010	2.498	✓			
2.75	+/-0.030	2.75	✓			
0.438	+/-0.010	0.433	✓			
0.080 x 45°	+/-0.010	0.080 x 45°	✓			
1.85	+/-0.030	1.846	✓			
1.000	+/-0.010	1.002	✓			
0.425	+/-0.010	0.421	✓			
0.030 x 45°	+/-0.010	0.034 x 45°	✓			
1.875	+/-0.010	1.880	✓			
0.375	+/-0.010	0.371	✓			
R0.25	+/-0.030	R.25	✓			
1.29	+/-0.030	1.29	✓			
0.414	+/-0.010	0.405	✓			
3.41	+/-0.030	3.39	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/03/30	Date:	09/04/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

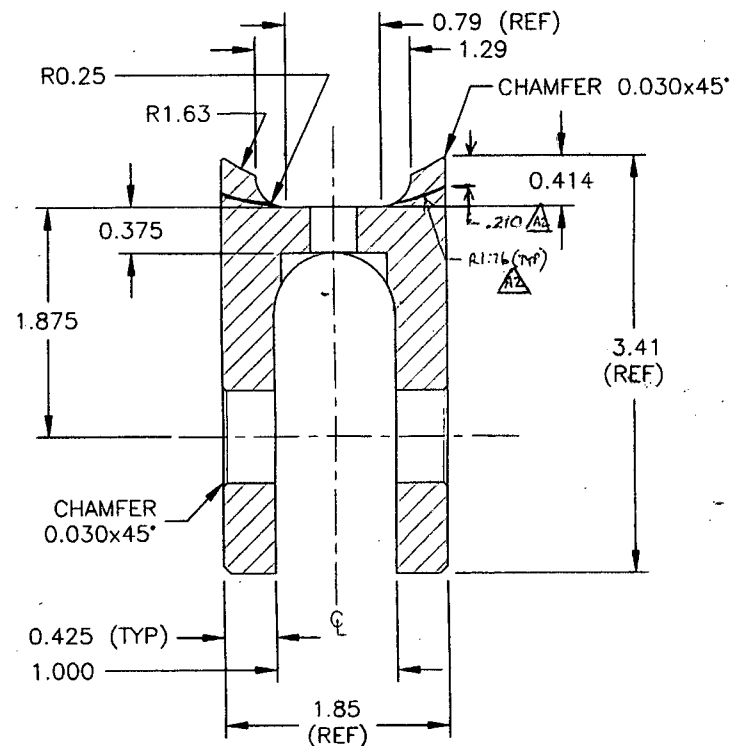
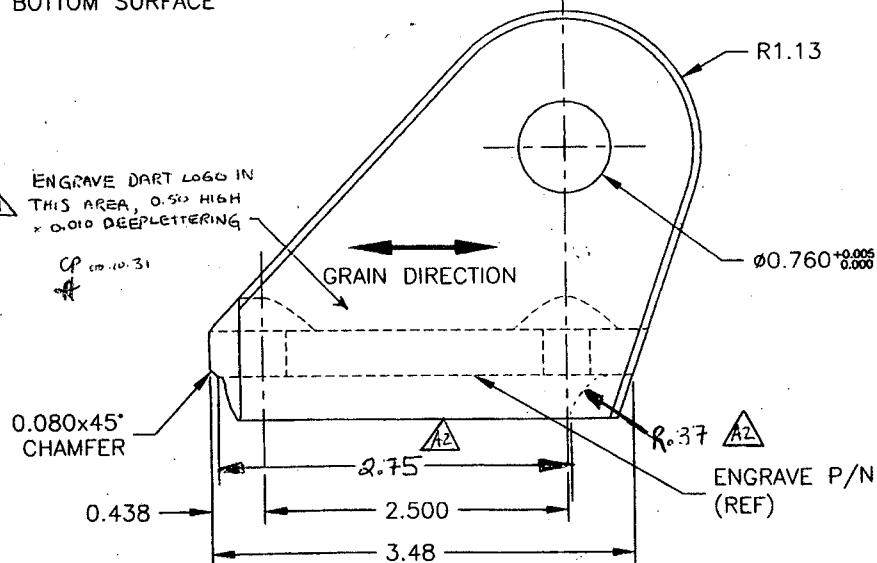
w/o 46688



ENGRAVE DART PART NUMBER AND BATCH NUMBER IN THIS AREA ON BOTTOM SURFACE

ENGRAVE DART LOGO IN THIS AREA, 0.50 HIGH x 0.010 DEEPLITERING

CP 10.31



SECTION A-A
SCALE 1:1

RELEASED
(99.07.09 DS)


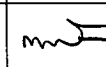
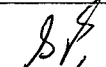
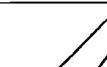
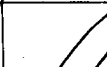



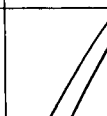
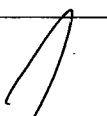
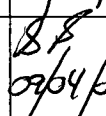

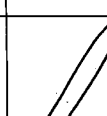
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE	
DESIGN	DRAWN BY CP	DART	DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED KE	DRAWING NO. D2888	REV. A SHEET 1 OF 1
DATE	99.06.21	TITLE LUG	SCALE 1:1

A2	04.04.08	Add Saddle Clearance for NCR 754	CP
A1	05.10.31	Update Engraving 00.10.31 CP	CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2888 PAR #: N/A Fault Category: Prod / Machine Parts NCR: (Yes) No DQA: D Date: 09/04/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: A Date: 09/04/09

NCR: <u>46688</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action, Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/30	3.0	Part machine wrong way in jig. Incorrect position. R.C. operator error.	 RCS1042	Scrap 2 destroy qty 1 No Replacement.	 09/03/30	 09/04/01	 RCS1042	 RCS103-30
09/04/01		On Rework Hole .760 $\pm .005$ $-.000$ due part move in the vise and oversize the hole too.791.	 RCS1042	Scrap 2 No replace;	 09/04/01	J.F. 09/04/01	 RCS1042	 RCS104/01
		R.C. operator error, set-up malfunction / Part spun out.	 RCS1042		 09/04/01	J.F. 09/04/01	 RCS1042	 RCS104/01

NOTE: Date & initial all entries